

Work Order ID 83787

Monday, May 28, 2012 9:57:40 AM

83787

DUPLICATE

Page 1

Item ID: D2989-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 5/4/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/11/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 12-05-28 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989 2- tack weld mesh on basket as per dwg D2989 using DT9445 jig ***cut cutouts with zip cut as per dwg D3832*** 3- remove from jig and weld lable plate as per dwg D2989 A/R ER316 S.S. Rod Batch: <u>1118161</u> *** PLEASE NOTE *** IF MAKING -043A : ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER DSI9473								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

12-05-28

12-05-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83787***83787***

Page 2

Item ID: D2989-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Basket Lid Assembly

Stop ***NS2***

Start Date: 5/4/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/11/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

8/26/28

125

Pressure Wash per QSI005 4.3

0.00

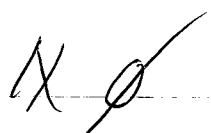
125

HandFinish

Memo

0.00

Hand Finishing

X  M-L
12/5/28

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref: 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:

START TIME: 4:00

OVEN TEMPERATURE: 400°F

FINISH TIME: 4:30

***** 2nd coat if necessary *****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

131

131

HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch D1505, 0.00

Memo

0.00

Mask lid prior to spray paint black and wing walk as per dwg
 A/R Spray paint black batch: 118/19

Handwritten: 1X ✓ 12/05/28

Handwritten: 1 ✓ DLD 529

Handwritten: m121134

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140 QC3- Inspect Part Finish 0.00

140

QC Memo 0.00

Quality Control

141 Identify as per dwg & Stock Location: *D350-607-013*

141

Packaging Memo 0.00

Packaging

150 QC21- Final Inspection - Work Order Release 0.00

150

QC Memo 0.00

Quality Control

8/12/05/30

83785

1 12/12/09

MCJ 12/05/30

MF 12-05-30

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Picklist Print

Monday, May 28, 2012 10:17:09 AM

Page 1

Work Order ID: 83787

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 5/4/2012

Required Date: 5/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M 10.09.14 added pressure
 wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	11.0000	2	2		12.05.28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		11							
				80163		1							
				83907		10							
D2506 Label Plate		Manufactured	No			100	Each	15.0000	1	1		12.05.28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		15							
				79197		4							
				82705		11							
D2512-7 Rib		Manufactured	No			100	Each	4.0000	1	1		12.05.28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		4							
				53444		0							
				81048		4							

71220 x 1

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Page 2

Work Order ID: 83787

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 5/4/2012

Required Date: 5/11/2012

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 70.0000 2 2 SL 12.05.28
Mounting Bracket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	20	
82506	2	
83230	18	
WA005	50	
70766	2	
81253	1	
82017	7	
82897	40	

D2989-13 Manufactured No 100 Each 6.0000 2 2 SL 12.05.28
Rib

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	6	
84604	6	

D2989-19 Manufactured No 100 Each 12.0000 2 2 SL 12.05.28
Rib

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	12	
77519	6	
84603	6	

D3832-3 Manufactured No 100 Each 2.0000 1 1 SL 12.05.28
Mesh (Lid)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA035	2	
77520	2	

Monday, May 28, 2012 10:17:09 AM

Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 83787

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 5/4/2012

Required Date: 5/11/2012

Start Qty: 1.00

Required Qty: 1.00

D3833-3
Mesh (Lid End) Manufactured No

100 Each 13.0000

2

2

WY 12.05.28

Location

Loc Qty

Loc Code

WA
81142
WA035
67460

4
4
9
9

D3836-041
Rib Assembly (Basket Lid, LH) Manufactured No

100 Each 4.0000

1

1

WY 12.05.28

Location

Loc Qty

Loc Code

WA
77515

4
4

D3836-042
Rib Assembly (Basket Lid, RH) Manufactured No

100 Each 4.0000

1

1

WY 12.05.28

Location

Loc Qty

Loc Code

WA005
77514

4
4

D3852-041
Rib Assembly Manufactured No

100 Each 2.0000

1

1

WY 12.05.28

Location

Loc Qty

Loc Code

WA005
77512

2
2

D3852-042
Rib Assembly Manufactured No

100 Each 3.0000

1

1

WY 12.05.28

Location

Loc Qty

Loc Code

WA
77513
WA005
66089
77513

1
1
2
1
1

Monday, May 28, 2012 10:17:10 AM

Shop Packet Print

Page 3

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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.05.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS	DRAWING NO.	REV. D
CHECKED	AS	D2989	SHEET 1 OF 5
MFG. APPR.	AS	TITLE	SCALE
APPROVED	AS	BASKET LID ASSEMBLY	NTS
DE APPR.	AS	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.09.24		

#83787

RELEASED
08/11/18

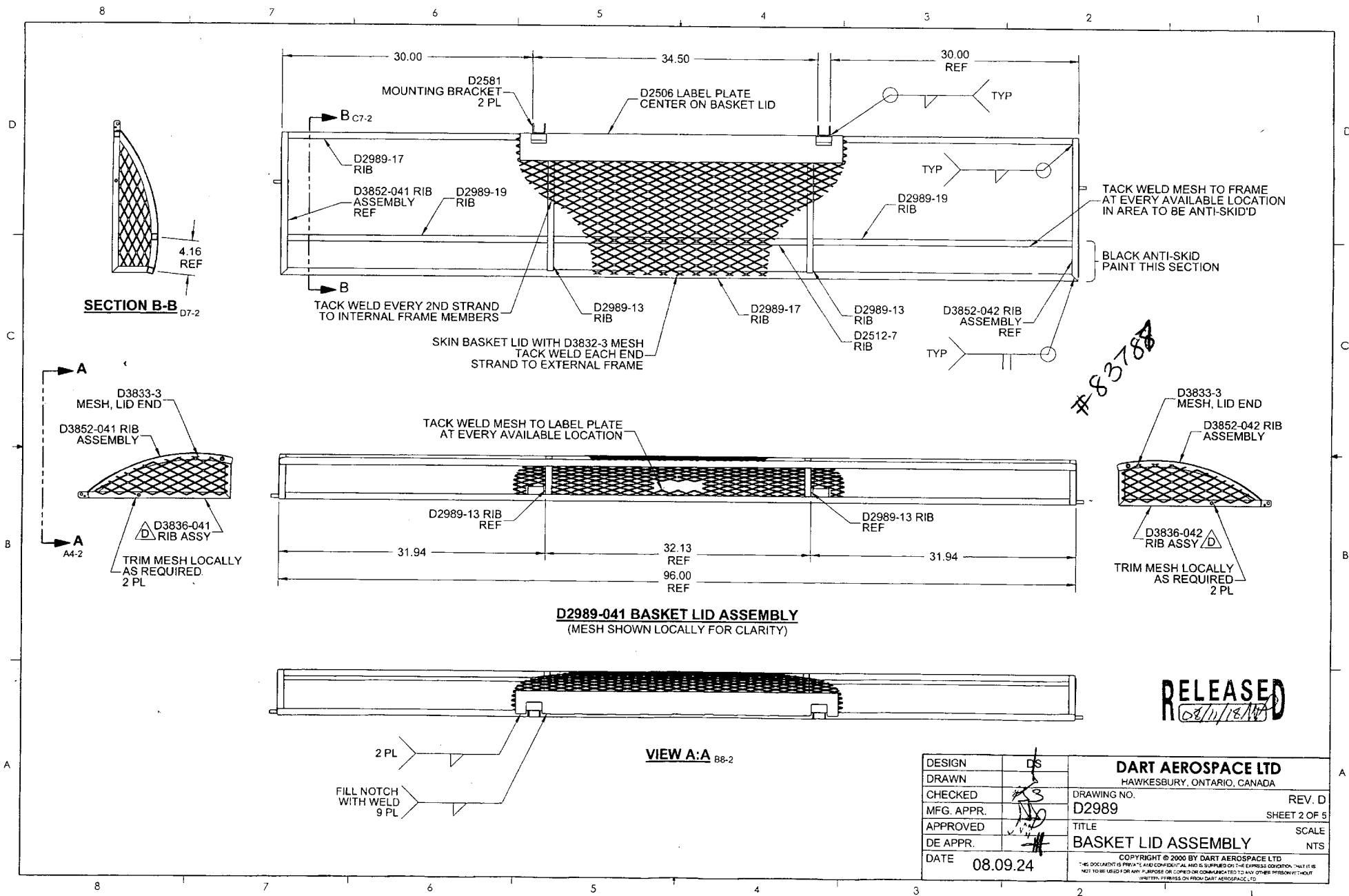
W/O:		WORK ORDER CHANGES					
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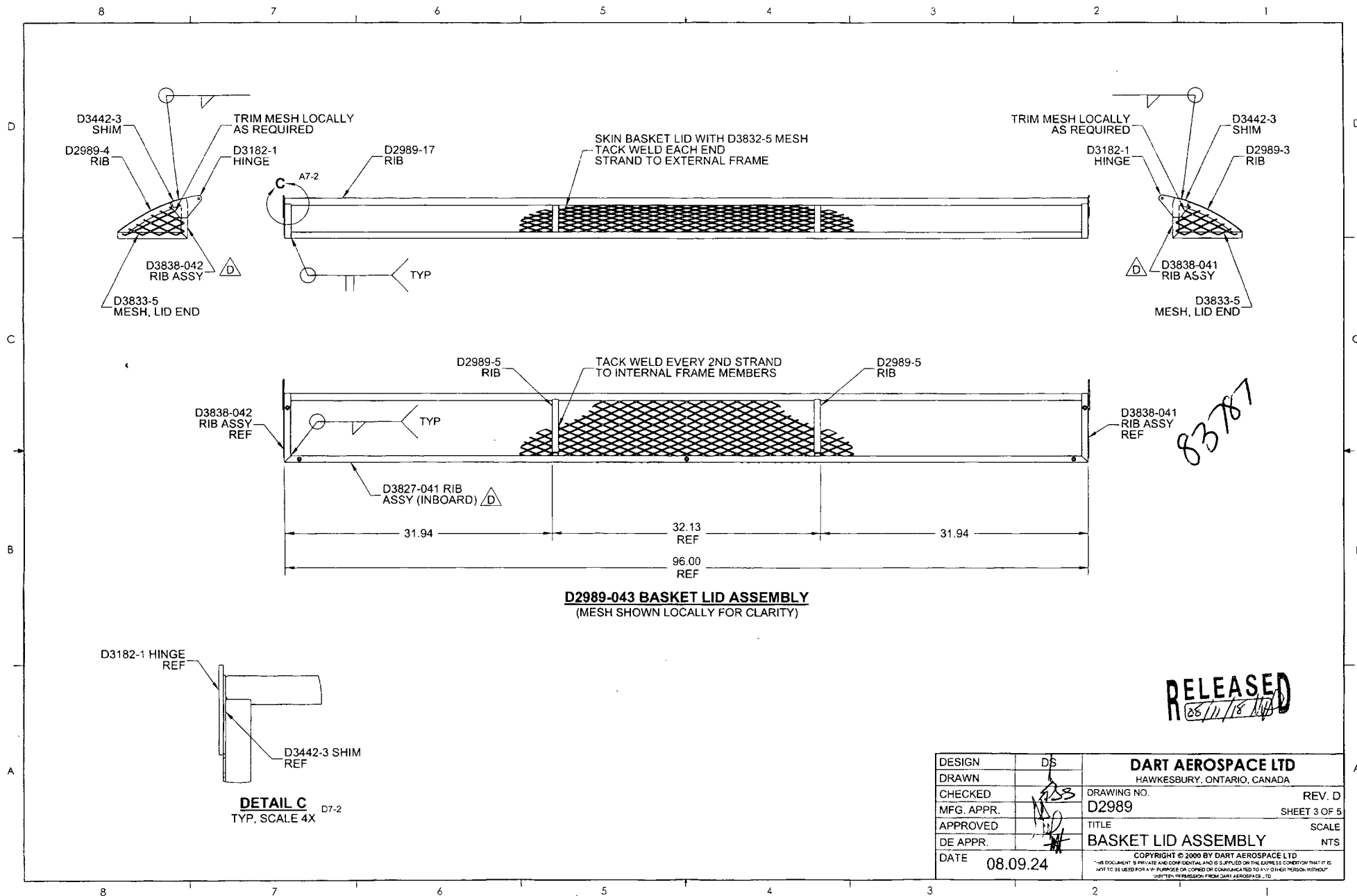
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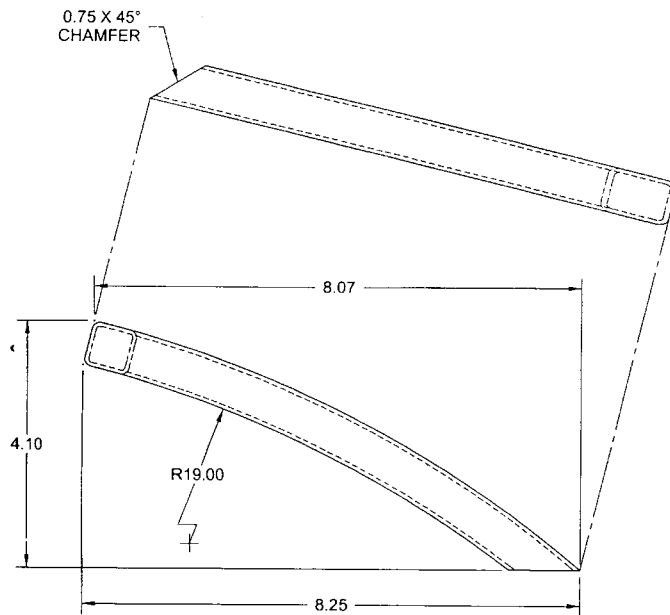
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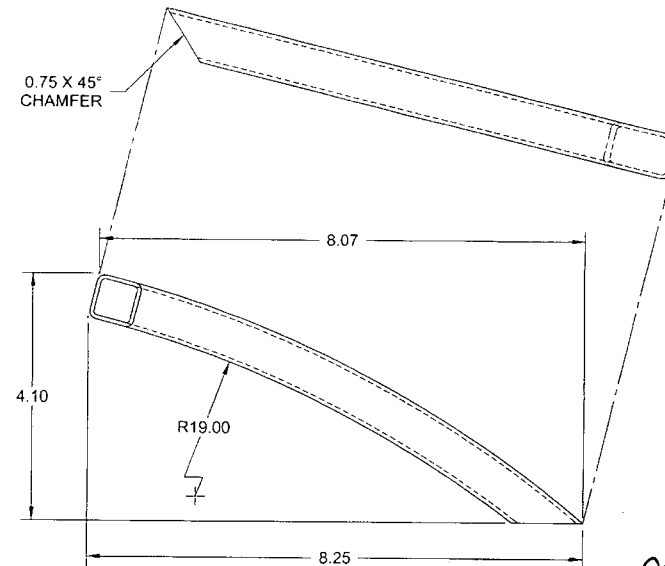
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D2989-3 RIB

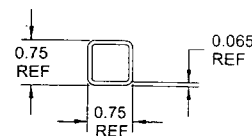


D2989-4 RIB

83787

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



TYPICAL SECTION VIEW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

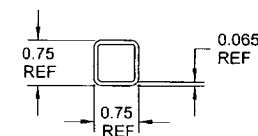
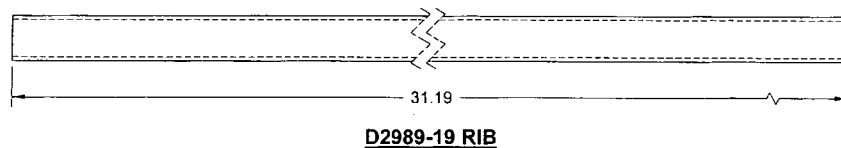
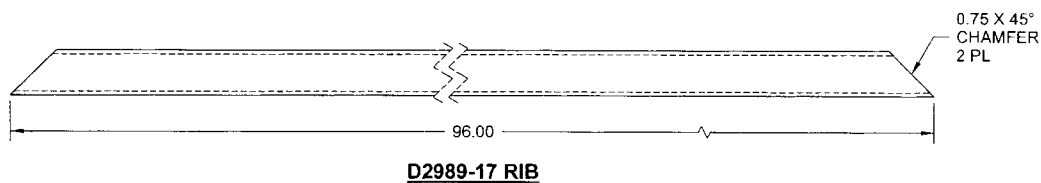
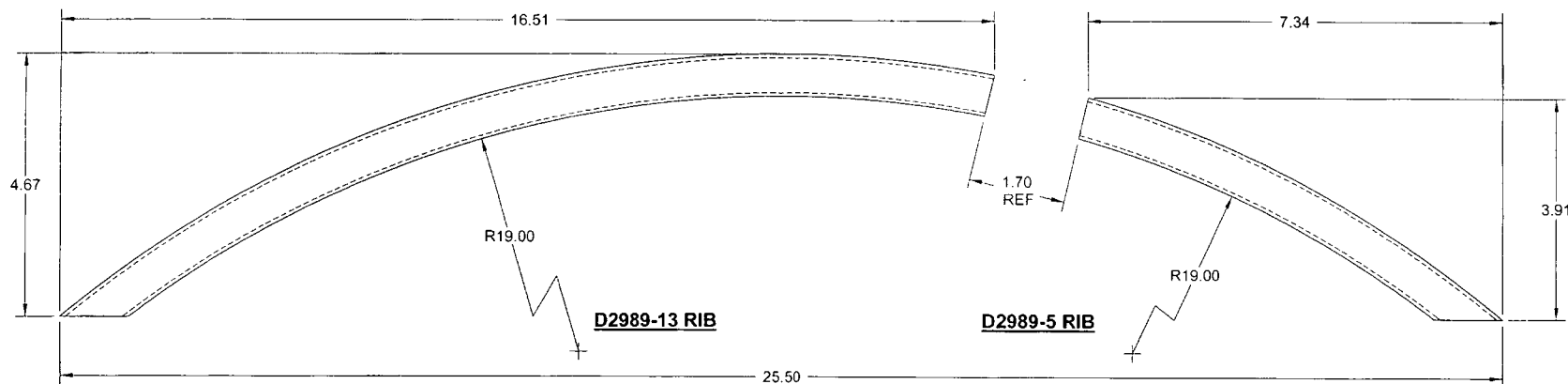
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TYPICAL SECTION
VIEW

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO.	REV. D
MFG. APPR.	SS	D2989	SHEET 5 OF 5
APPROVED	SS	TITLE	SCALE
DE APPR.	SS	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Parent Item ID	Reason	Lot Qty	Lot Nbr	Lot Trans Date
D2221-1	83787	-2	80163	5/17/2012 13:16
D2506	83787	-1	79197	5/17/2012 13:16
D2512-7	83787	-1	71220	5/17/2012 13:16
D2581	83787	-2	82017	5/17/2012 13:16
D3833-3	83787	-2	81142	5/17/2012 13:16
D3836-041	83787	-1	77515	5/17/2012 13:16
D3836-042	83787	-1	77514	5/17/2012 13:16
D3852-041	83787	-1	77512	5/17/2012 13:16
D3852-042	83787	-1	77513	5/17/2012 13:16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries